

Date: Wednesday, 12/5/2007 8:02:10 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP HI LONG
 Job Number : 36115 -2
 Estimate Number : 12897
 P.O. Number : N/A
 This Issue : 12/5/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : LARGE FAB ASSY
 Previous Run : 35805
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 07-06-09 JLM

Part Number : D32721
 Drawing Number : D3272 REV B
 Project Number : N/A
 Drawing Revision : B
 Material : N/A
 Due Date : 12/20/2007 Qty: 28 Um: Each

Split
12.01.12.06
(5)

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 Pick:

Qty	Part Number	Description	Batch
1	D2622-120	Extrusion	534694

a.m 07.12.06

(5)

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A *a.m 07.12.06* *(5)*

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets. *a.m 07.12.06* *(5)*

3-Deburr

a.m 07.12.06 *(5)*

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07.12.06 *(5)*

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *int*

12.01.12.06 *(5)*

Date: Wednesday, 12/12/2007 8:02:10 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP HI LONG

Job Number: 36115

Part Number: D32721

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC21

FINAL INSPECTION/W/O RELEASE



5

Comment: FINAL INSPECTION/W/O RELEASE

12/12/06

Job Completion



12/12/06



DESIGN <i>qp</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *[Signature]*

△
B

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

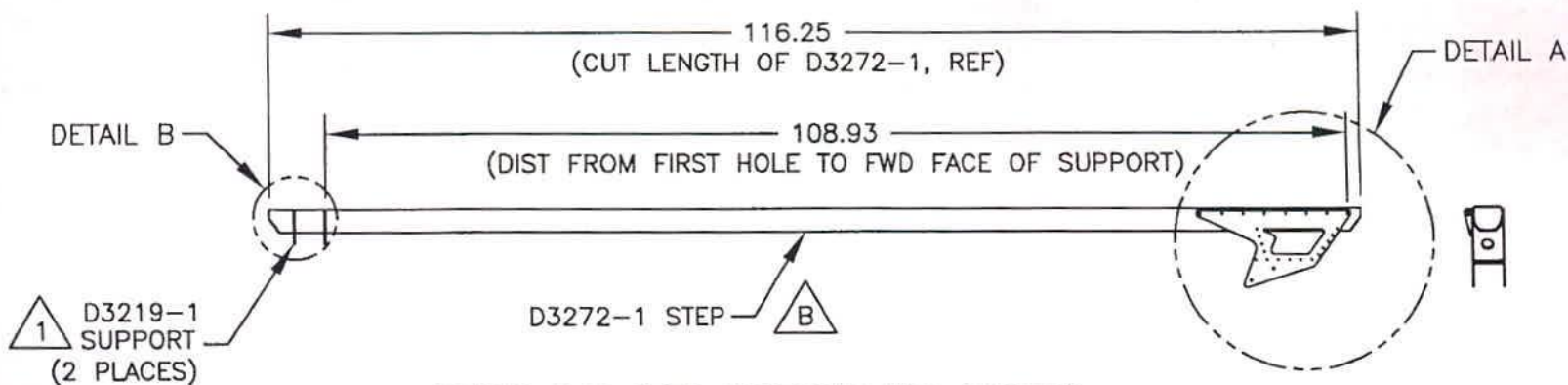
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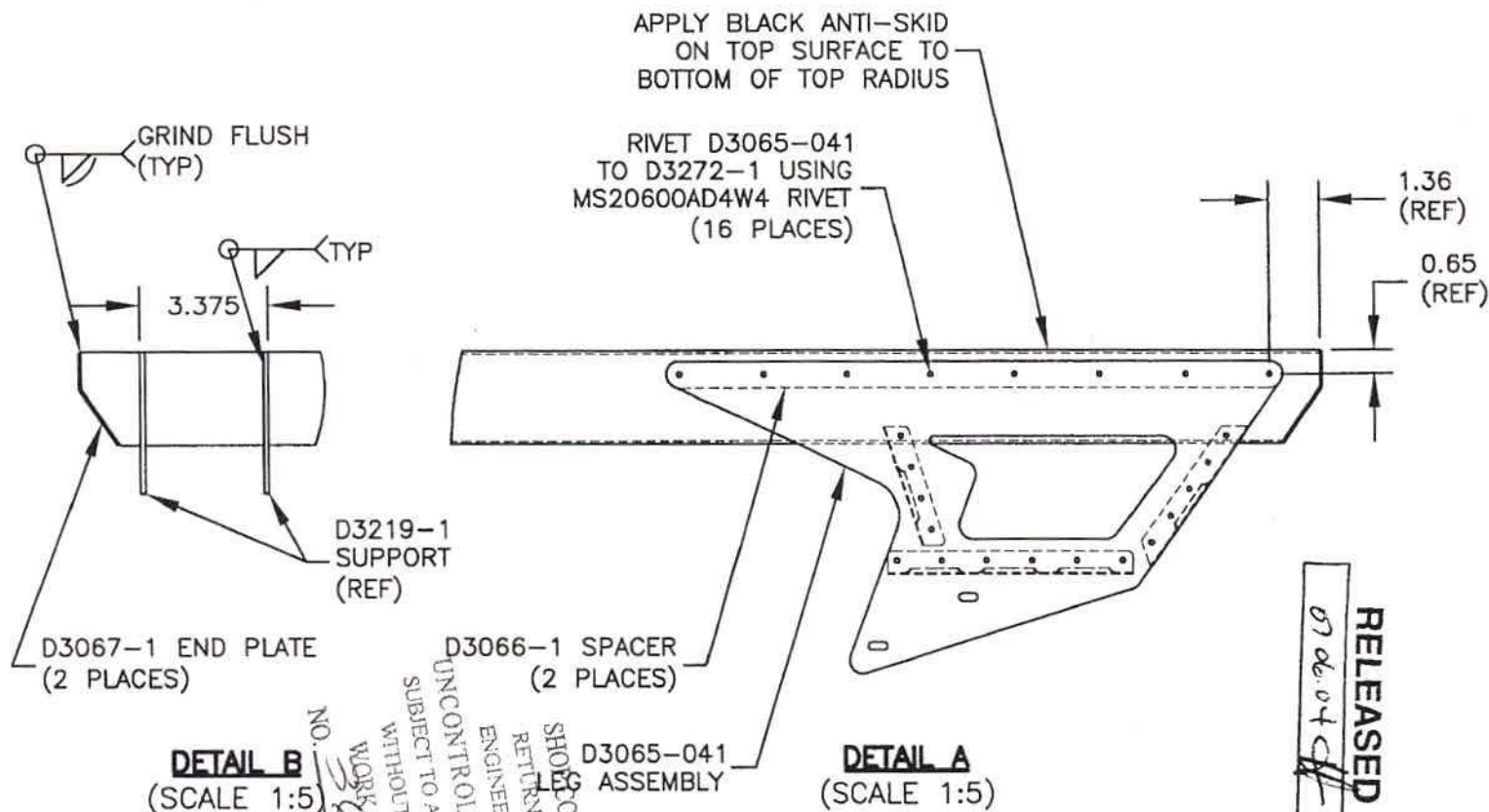
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DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
		SCALE	1:20	



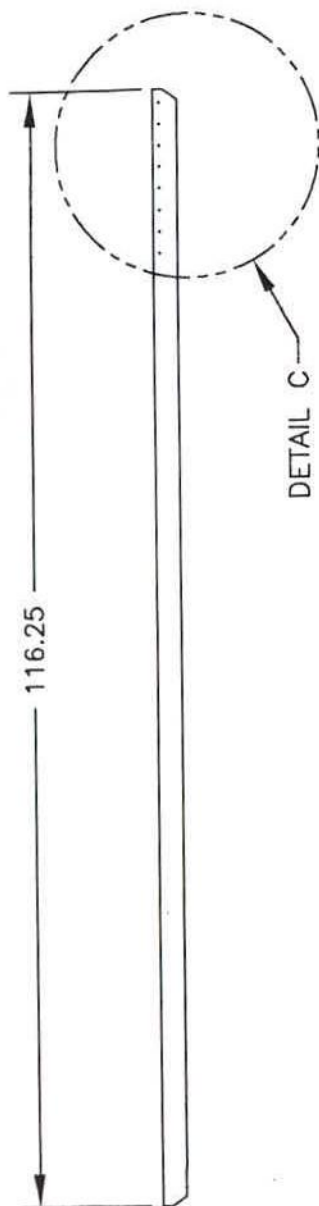
D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



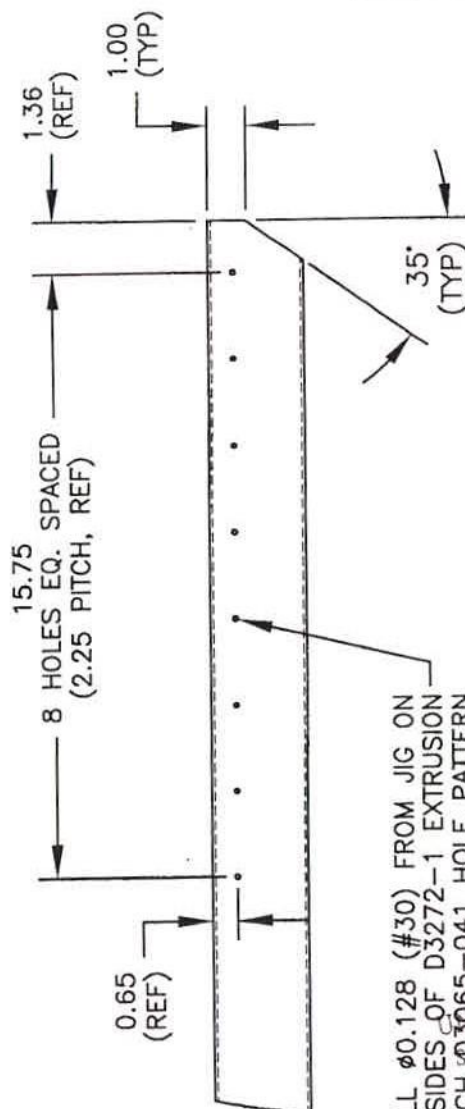
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DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20



B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

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